

Work Order ID 61516

Monday, August 30, 2010 9:17:54 AM



Page 1

Item ID: D3824-1KIV

Accept



Setup Start



Revision ID:

Item Name: Hat Bin-Ivory

Stop



Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-8-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

(X) B 10/10/07

105

0.00



HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per PSN 22 KYDEX

Temp:

140°F

Time IN:

4:30 10/10/06

Time OUT:

7:00 10/10/07

B 10/10/07

26x54.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA033 using tool DT9405 Dwg Rev: <u>S</u> Folio Rev: <u>B</u>	0.00				(X)			B 10/10/07
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00				(X)			B 10/10/07
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00				(X)			B 10/10/07

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(b) (7)(C), (b) (7)(D)

Page 3

Accept

[illegible]**Setup Start**

Stop

Author's address: Department of Psychology,
University of California, San Diego,
La Jolla, CA 92037, USA.
E-mail: jacob@ucsd.edu

Cust Item ID:[illegible]

Customer:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

0.00

Abstract

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

0.00

[illegible]

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

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Page 4

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Item Name: Hat Bin-Ivory

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 51-

0.00



Packaging

Memo

0.00

Packaging

mf
10-10-07

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/07 *[Signature]**mf*
10-10-07

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, August 30, 2010 9:17:59 AM

Page 1

Work Order ID: 61516



Parent Item: D3824-1KIV



Parent Item Name: Hat Bin-Ivory

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry material 10/04/21 DL

Ipp Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3- 62015		Purchased		No		100	sf	974.5400	11.41	11.41571			



6185 KYDEX .125"

Location

Loc Qty

Loc Code

therm

974.54

110426

974.54

MF 10-10-07

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DART AEROSPACE LTD		Work Order:	<i>61514</i>
Description: Hat Bin		Part Number:	D3824-1KIV/KGY
Inspection Dwg: D3824	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	<i>✓</i>			
Shape Definition	<i>✓</i>			
Texture Retention	<i>✓</i>			
Material imperfections such as bumps, cracks, voids, scratching	<i>✓</i>			

Measured by: _____

Date: _____

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+0.05/-0.00	<i>0.46</i>	<i>✓</i>			
48.5	Ref	<i>48.5"</i>	<i>✓</i>			
34.1	Ref	<i>34.0"</i>	<i>✓</i>			
41.6	Ref	<i>41.6"</i>	<i>✓</i>			
3.5	Ref	<i>3.5"</i>	<i>✓</i>			
0.055	Min	<i>0.106"</i>	<i>✓</i>			
<i>0.030</i>	<i>M.N</i>	<i>0.043"</i>	<i>✓</i>			

Measured by: *DR.*

Date: *10/10/07*

Audited by: *EB*

Date: *10/10/07*

Prototype Approval: _____

N/A

Date: _____

N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

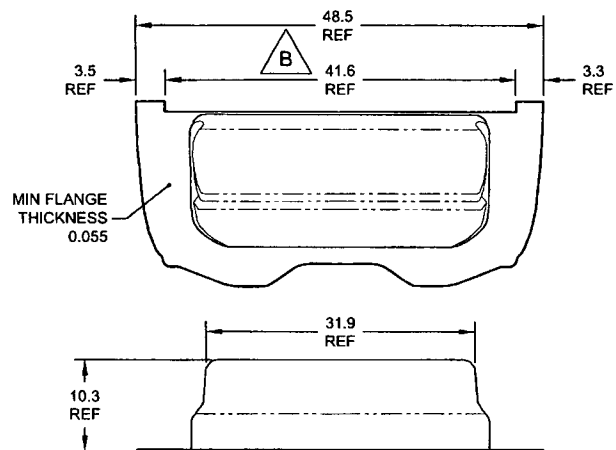
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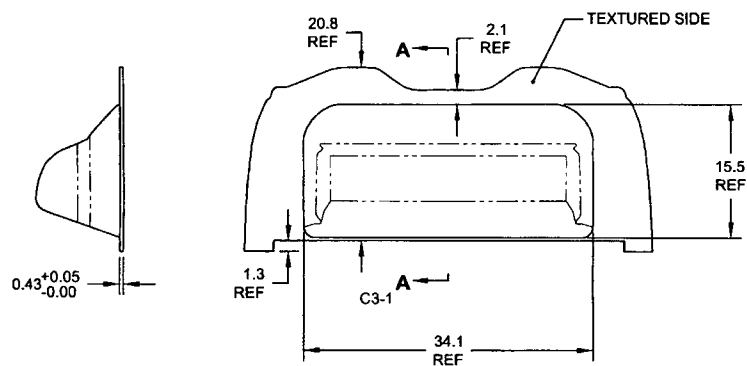
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SECTION A-A
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61514*
PSO-8-30



D3824-1 HAT BIN
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD

PART NUMBER	DESCRIPTION
D3824-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY; MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2)	PH	09.02.19
A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3824** REV. C
SHEET 1 OF 2
TITLE **HAT BIN (BELL 206 A/B)** SCALE NTS

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RELEASED
01/25/14

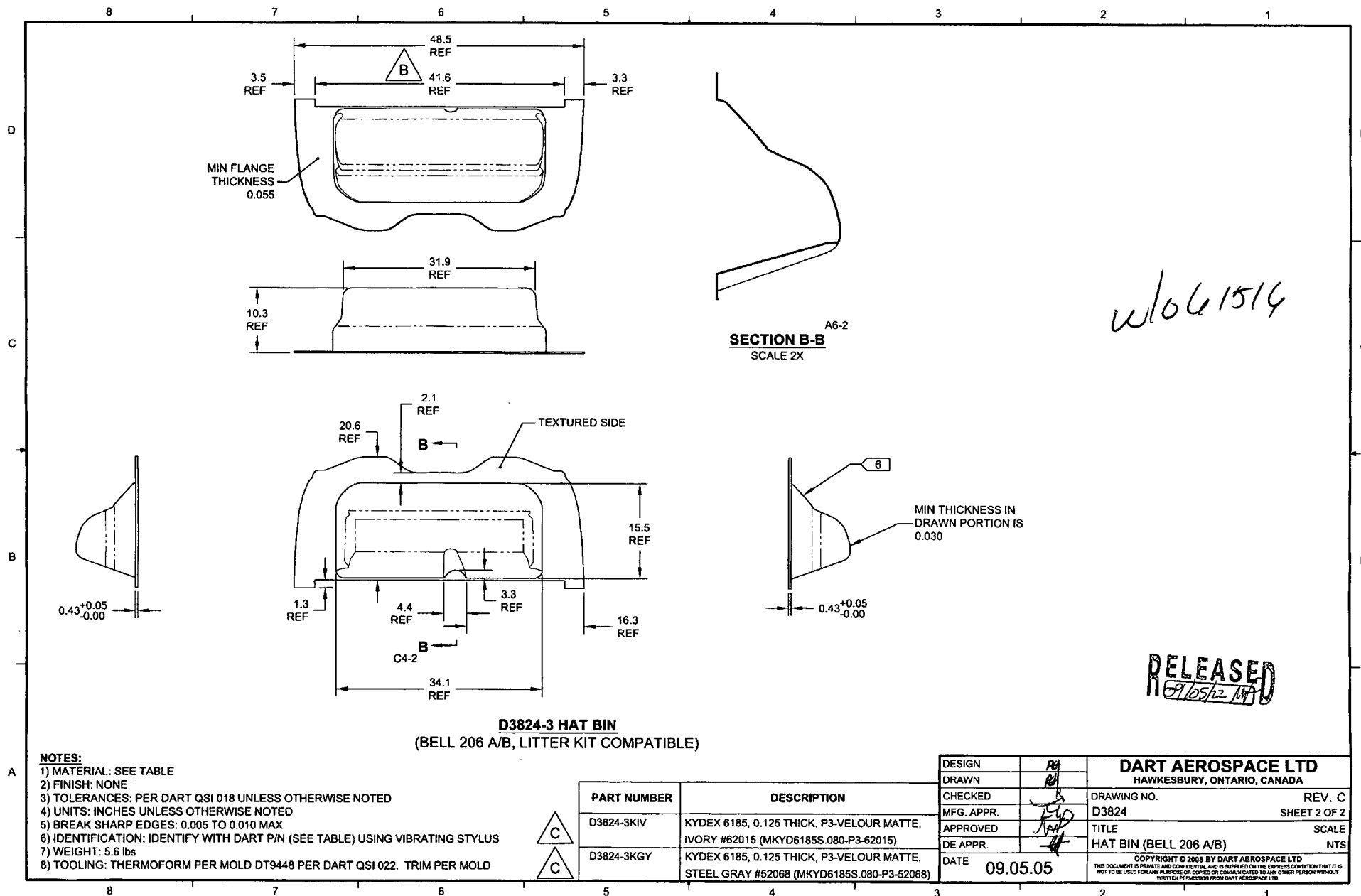
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